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(54) **SYSTEMS AND METHODS TO INCREASE RIGIDITY AND SNAG-RESISTANCE OF CATHETER TIP**

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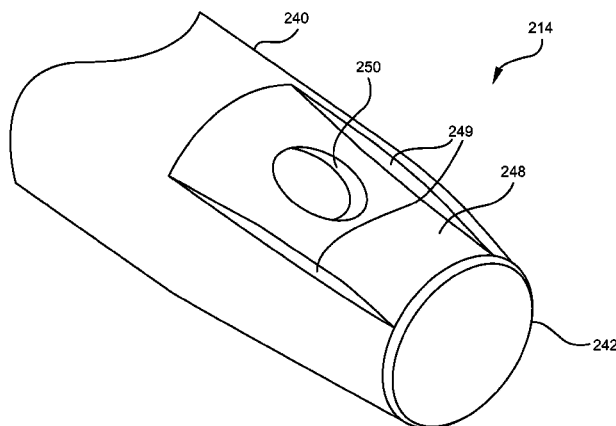
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(57) **ABSTRACT**

A venous catheter having a catheter tip comprising recessed diffusion holes for increasing the snag-resistance of the venous catheter. The invention further provides systems and methods for providing axial ridges interposed between diffusion holes for increasing the rigidity of the vented catheter tip.

20 Claims, 9 Drawing Sheets



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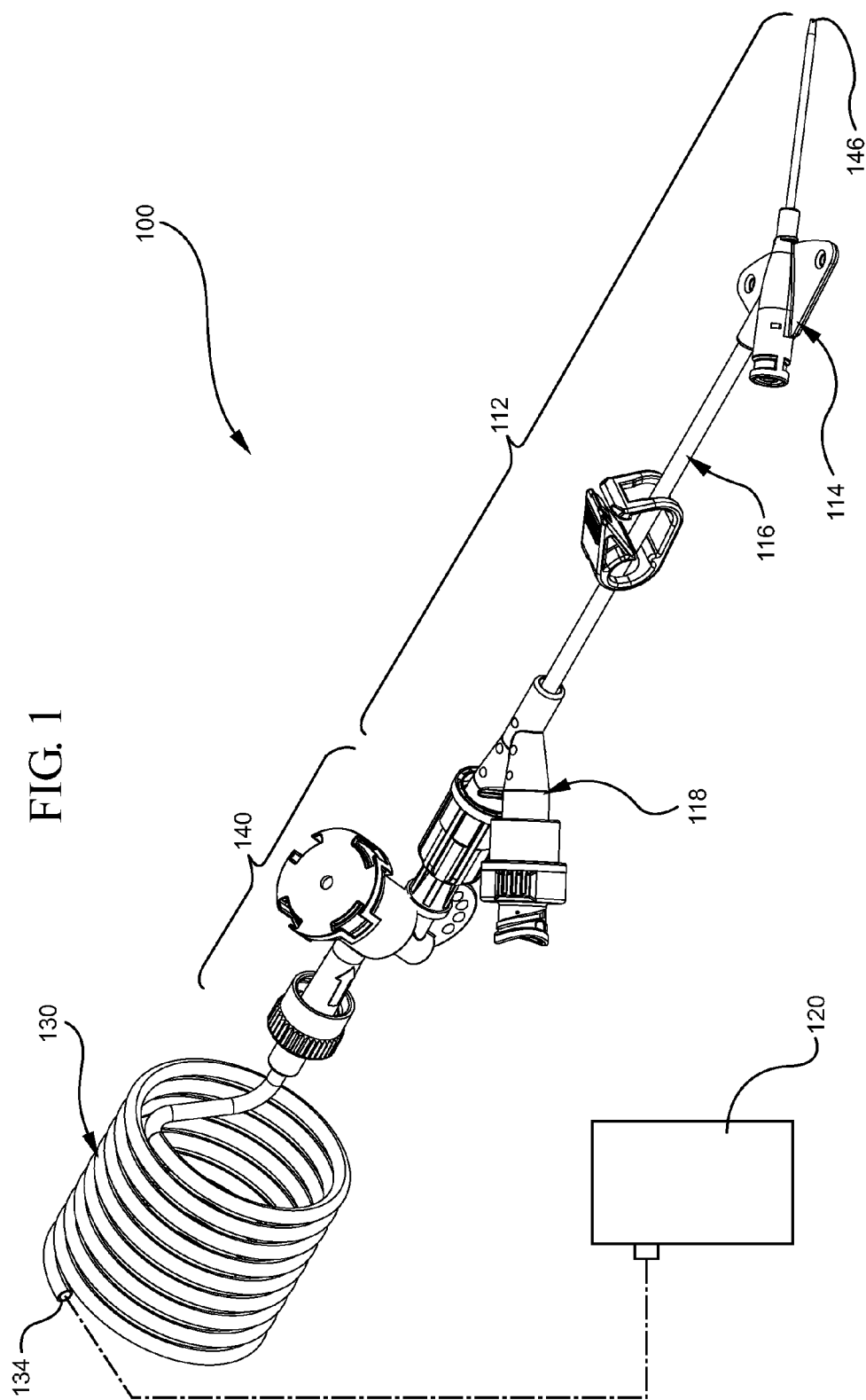


FIG. 2

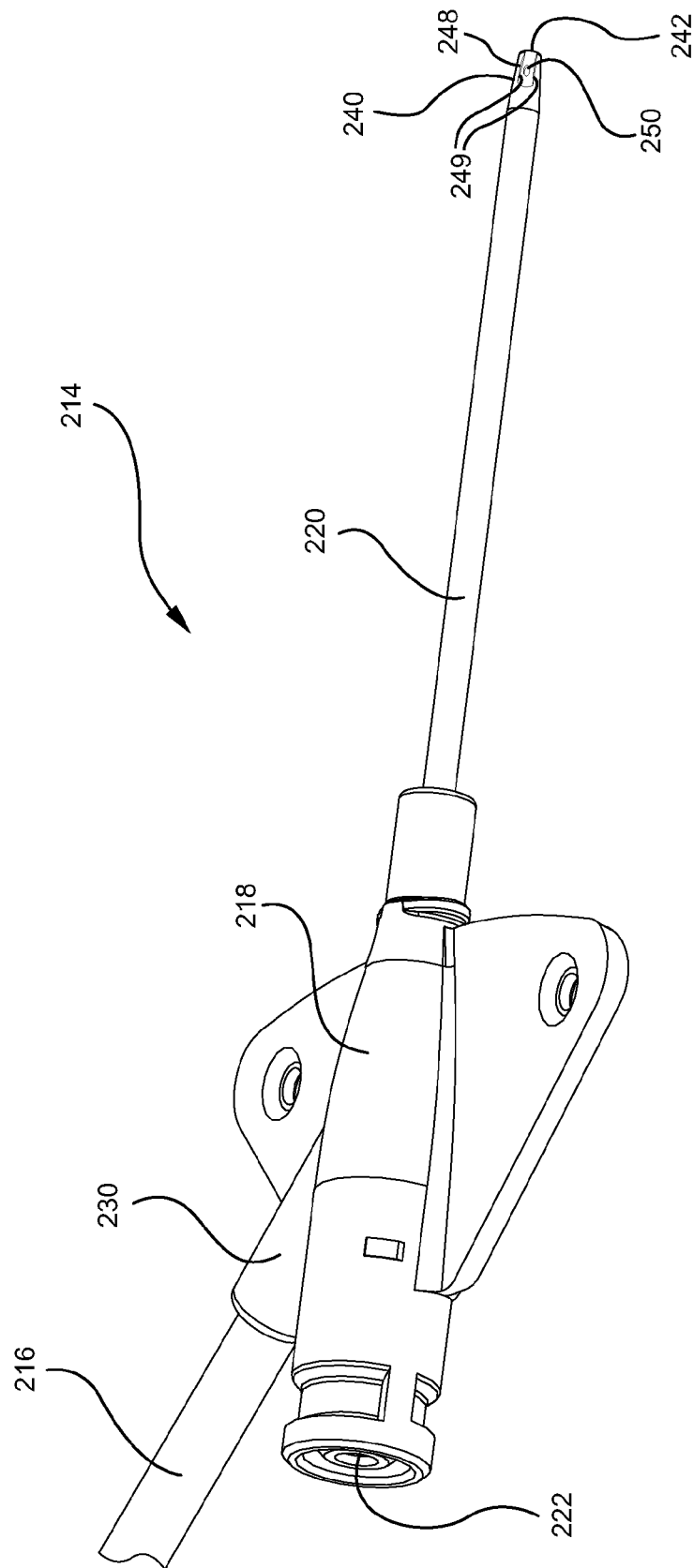


FIG. 3

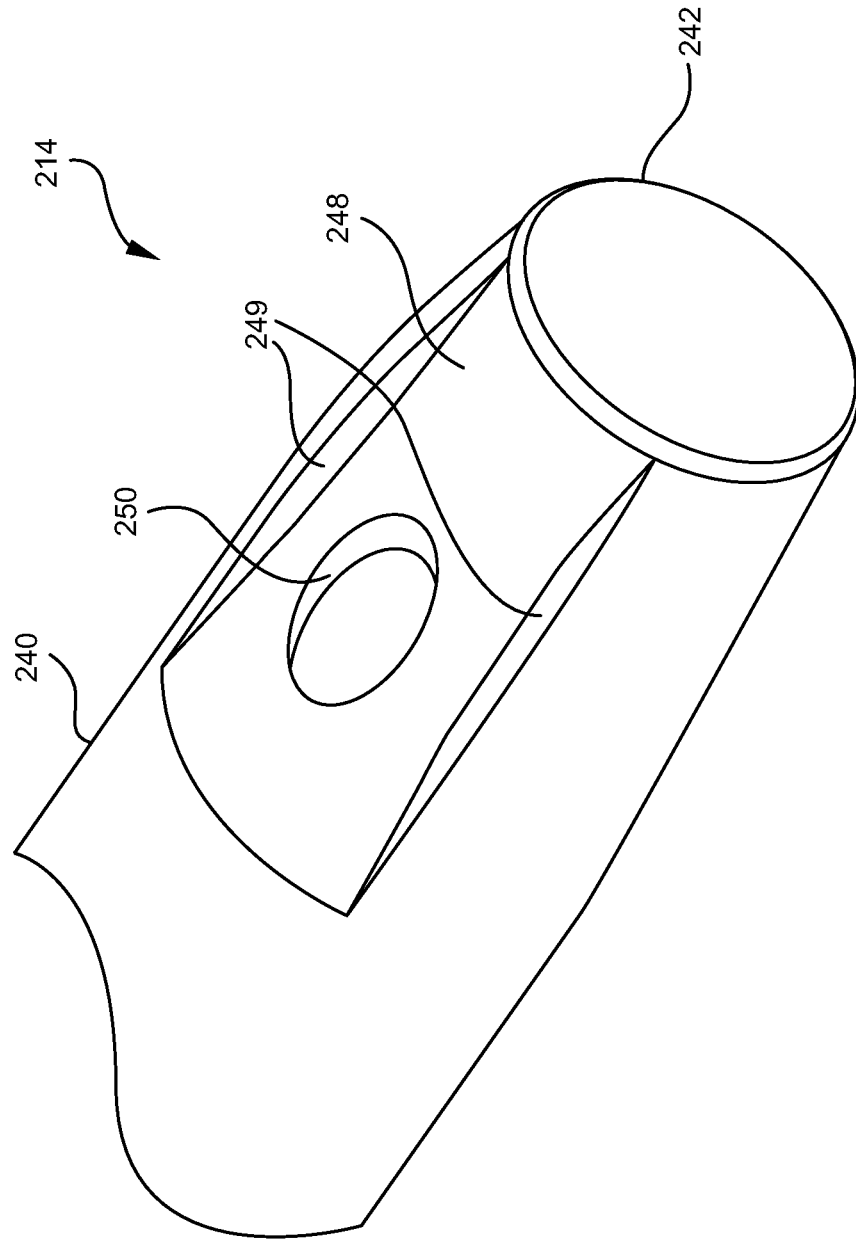


FIG. 4

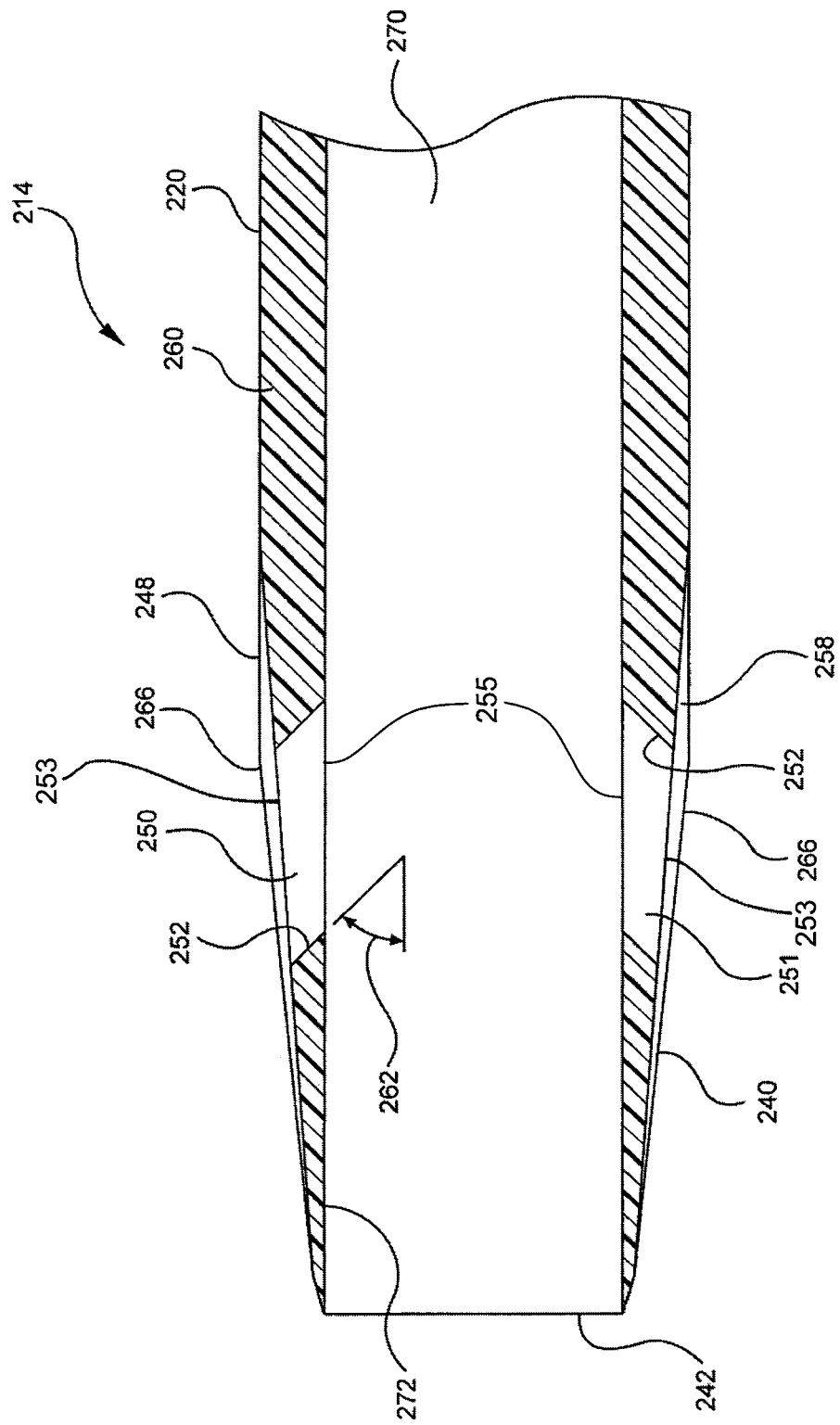


FIG. 5

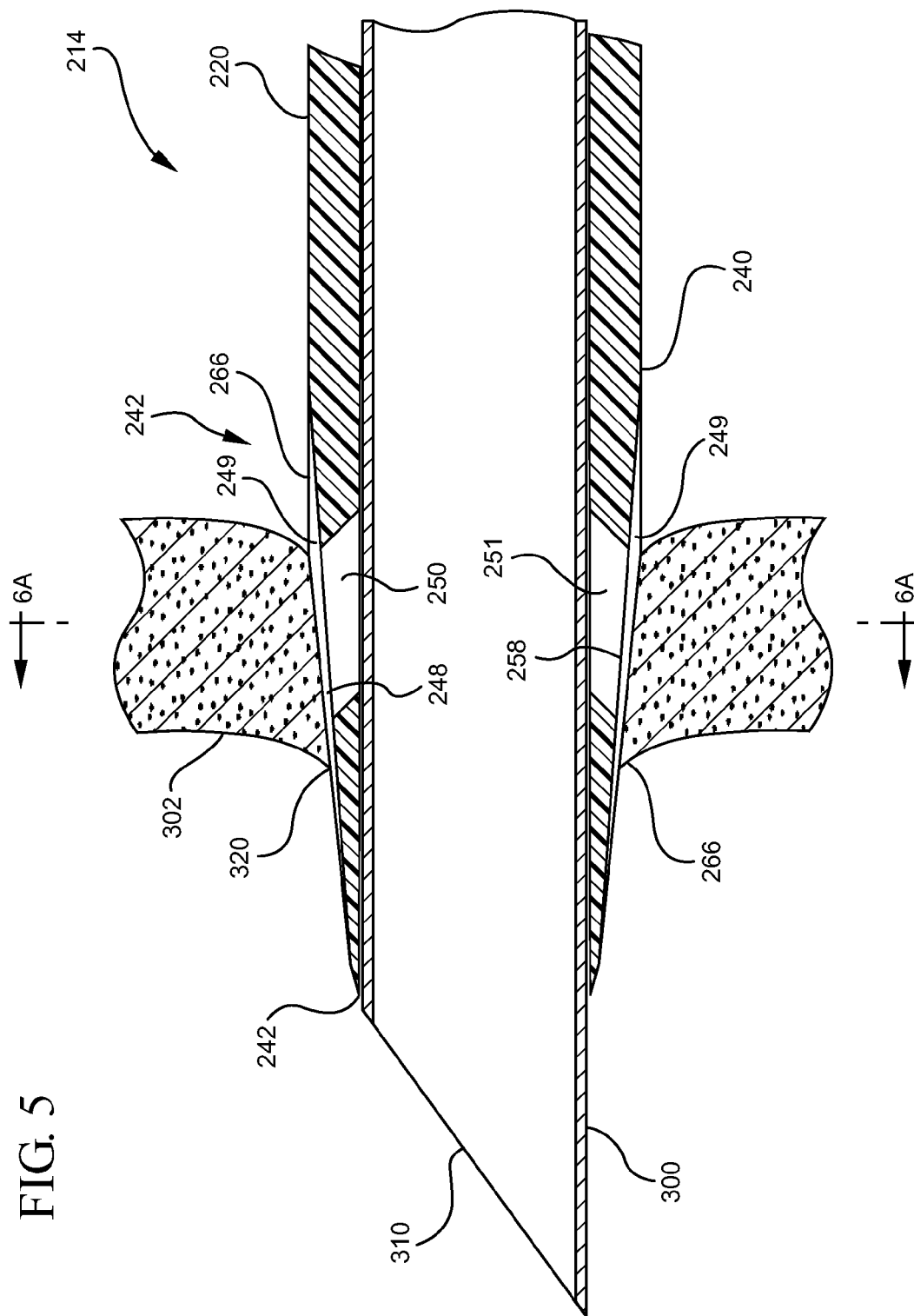


FIG. 6A

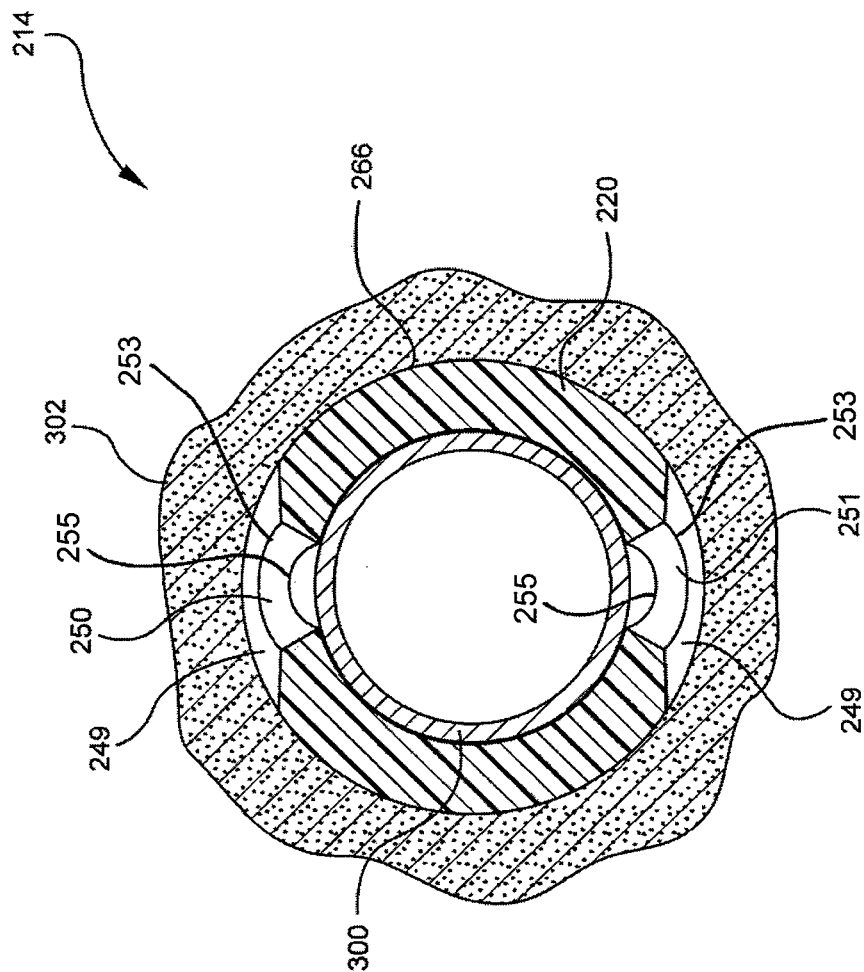


FIG. 6B

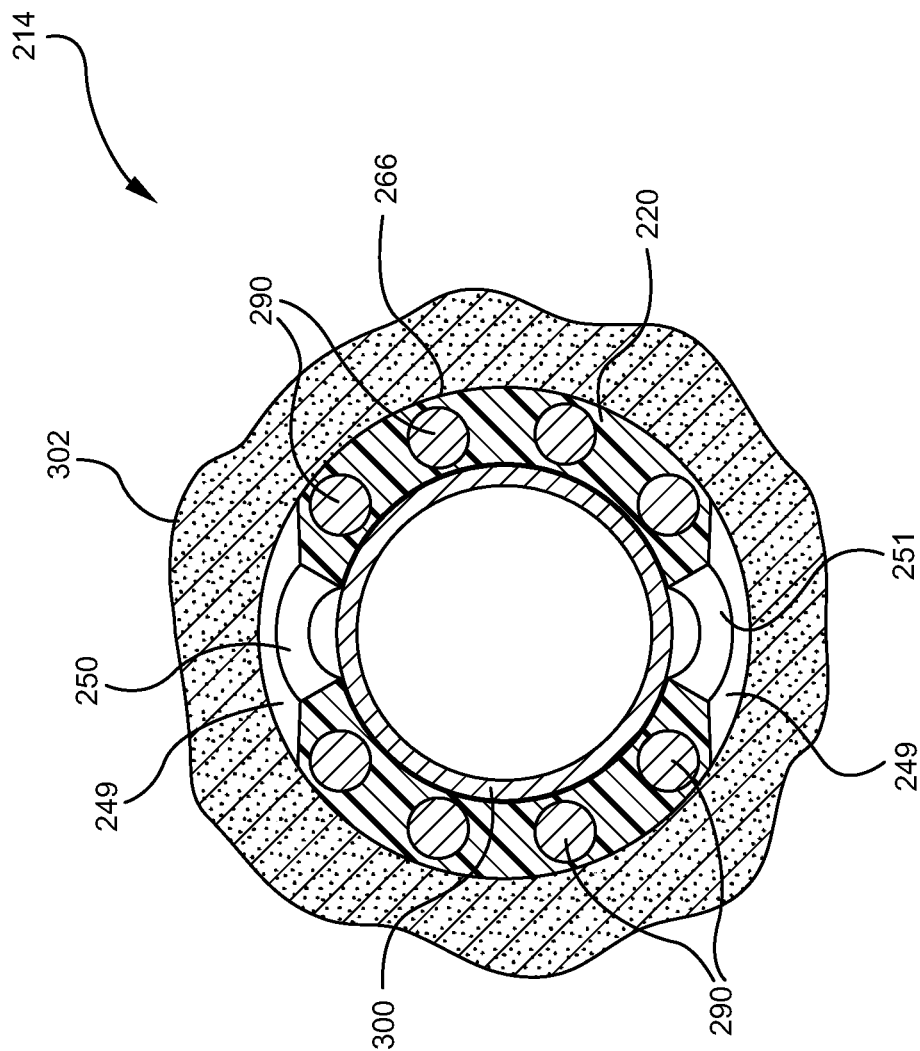


FIG. 7

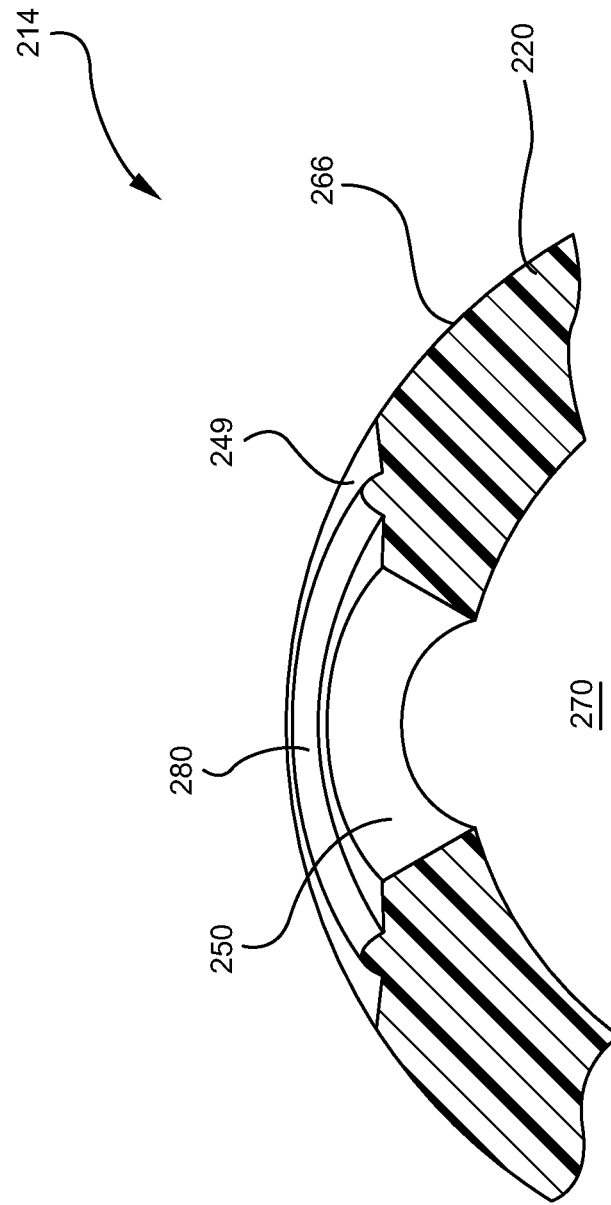
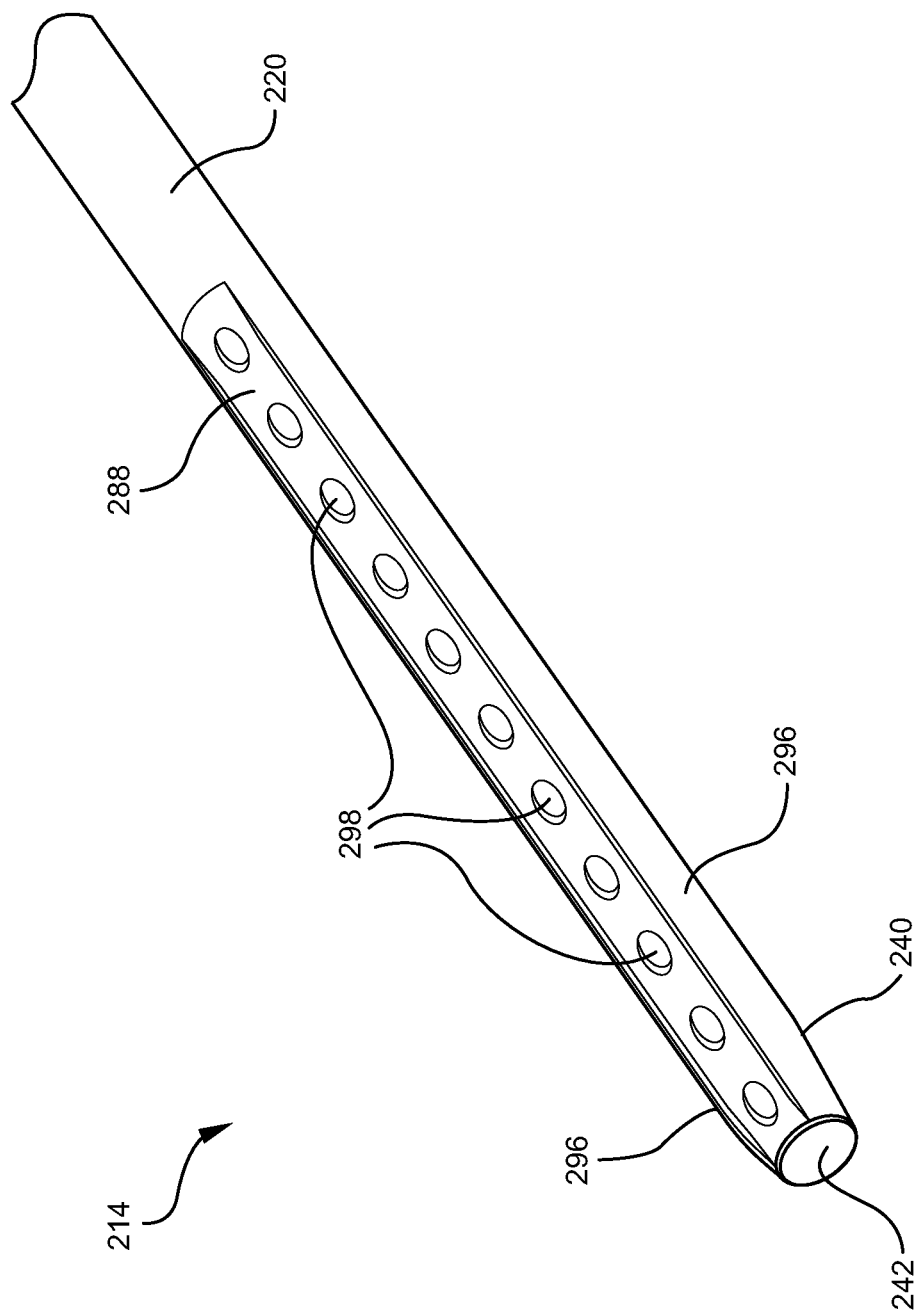


FIG. 8



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SYSTEMS AND METHODS TO INCREASE RIGIDITY AND SNAG-RESISTANCE OF CATHETER TIP

BACKGROUND OF THE INVENTION

The present invention relates generally to vascular infusion systems and components, including catheter assemblies and devices used with catheter assemblies. In particular, the present invention relates to systems and methods for increasing the rigidity and snag-resistance of a catheter tip of a vascular infusion system having catheter hole arrays to provide enhanced infusion flow rates, lower system pressures, and reduced catheter exit jet velocities. Additionally, the present invention relates to improving the overall rigidity of a thin-walled structure.

Vascular access devices are used for communicating fluid with the anatomy of a patient. For example, vascular access devices, such as catheters, are commonly used for infusing fluid, such as saline solution, various medicaments, and/or total parenteral nutrition, into a patient, withdrawing blood from a patient, and/or monitoring various parameters of the patient's vascular system.

A variety of clinical circumstances, including massive trauma, major surgical procedures, massive burns, and certain disease states, such as pancreatitis and diabetic ketoacidosis, can produce profound circulatory volume depletion. This depletion can be caused either from actual blood loss or from internal fluid imbalance. In these clinical settings, it is frequently necessary to infuse blood and/or other fluid rapidly into a patient to avert serious consequences.

Additionally, the ability to inject large quantities of fluid in a rapid manner may be desirable for certain other medical and diagnostic procedures. For example, some diagnostic imaging procedures utilize contrast media enhancement to improve lesion conspicuity in an effort to increase early diagnostic yield. These procedures necessitate viscous contrast media be injected by a specialized "power injector" pump intravenously at very high flow rates, which establishes a contrast bolus or small plug of contrast media in the bloodstream of the patient which results in enhanced image quality.

Power injection procedures generate high pressures within the infusion system, thereby requiring specialized vascular access devices, extension sets, media transfer sets, pump syringes, and bulk or pre-filled contrast media syringes. As the concentration (and thereby viscosity) and infusion rate of the contrast media are increased, bolus density also increases resulting in better image quality via computed tomography (CT) attenuation. Therefore, a current trend in healthcare is to increase the bolus density of the contrast media by increasing both the concentration of the contrast media and the rate at which the media is infused into the patient, all of which ultimately drives system pressure requirements higher.

Intravenous infusion rates may be defined as either routine, generally up to 999 cubic centimeters per hour (cc/hr), or rapid, generally between about 999 cc/hr and 90,000 cc/hr (1.5 liters per minute) or higher. For some diagnostic procedures utilizing viscous contrast media, an injection rate of about 1 to 10 ml/second is needed to ensure sufficient bolus concentration. Power injections of viscous media at this injection rate produce significant back pressure within the infusion system that commonly results in a failure of the infusion system components.

Traditionally, rapid infusion therapy entails the use of an intravenous catheter attached to a peristaltic pump and a fluid source. A patient is infused as a tip portion of the catheter is inserted into the vasculature of a patient and the pump forces

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a fluid through the catheter and into the patient's vein. Current rapid infusion therapies utilize a catheter and catheter tip with geometries identical to those used with traditional, routine infusion rates. These geometries include a tapering catheter tip such that the fluid is accelerated as the fluid moves through the catheter tip and exits into a patient's vasculature. This acceleration of the infused fluid is undesirable for several reasons.

For example, the tapered catheter results in a greater back-pressure for the remainder of the catheter assembly. This effect is undesirable due to the limitations of the pumping capacity of the infusion pump as well as the limited structural integrity of the components and subcomponents of the infusion system. For example, if the backpressure becomes too great, the pump's efficiency may decrease and certain seals or connections within the infusion system may fail. Additionally, the fluid acceleration in the catheter tip results in a recoil force that may cause the catheter tip to shift within the patient's vein thereby displacing the catheter and/or damaging the patient's vein and/or injection site. Fluid acceleration also increases the jet velocity of the infusant at the tip of the catheter. In some procedures, the fluid jet may pierce the patient's vein wall thereby leading to extravasation or infiltration. Not only is this uncomfortable and painful to the patient, but infiltration may also prevent the patient from receiving the needed therapy.

To overcome undesirable backpressures and increased acceleration of infused fluids, some intravascular systems include arrays of diffuser holes provided in and around the tip portion of the intravenous catheter. Examples of arrays of diffuser holes and diffuser hole geometries are provided in U.S. patent application Ser. Nos. 12/427,633 and 13/022,501, each of which are incorporated herein by reference.

In general, diffuser holes increase the surface area of the catheter tip opening thereby decreasing fluid pressure at the catheter tip opening. However, addition of diffuser holes at or near the tip of a catheter also reduces the buckling resistance of the catheter thereby making the catheter tip more susceptible to crushing during insertion. As a result, the addition of diffuser holes may result in failed catheterization and physical pain to the patient. Further, addition of diffuser holes provides the catheter with a non-continuous outer surface that may snag or catch on the opening of the patient's skin and/or vein through which the catheter is inserted. This too may result in failed catheterization, physical pain and/or physical damage to the patient.

Thus, while methods and systems currently exist to reduce exit velocity of an infusant during rapid infusion procedures, challenges still exist. Accordingly, it would be an improvement in the art to augment or even replace current techniques with other techniques.

BRIEF SUMMARY OF THE INVENTION

The systems and methods of the present disclosure have been developed in response to problems and needs in the art that have not yet been fully resolved by currently available infusion systems and methods. Thus, these systems and methods are developed to provide for safer and more efficient rapid infusion procedures.

One aspect of the present invention provides an improved vascular access device for use in combination with a vascular infusion system capable of rapidly delivering an infusant to the vascular system of a patient. The vascular access device generally includes an intravenous catheter configured to access the vascular system of a patient. The intravenous catheter is coupled to the vascular infusion system via a section of

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intravenous tubing. The material of the intravenous catheter may include a polymer or metallic material compatible with infusion procedures.

In some embodiments, a tip portion of the intravenous catheter is modified to include a plurality of diffusion holes. The tip portion generally comprises a tapered profile, wherein the outer and inner surface of the tip taper towards the distal end of the catheter. The tapered outer surface provides a smooth transition between the narrow diameter of the catheter tip opening and the larger diameter of the catheter tubing. Thus, as the tip of the catheter is introduced into the vein of a patient, the tapered outer surface facilitates easy insertion of the catheter through the access hole. The tapered inner surface is generally provided to tightly contact the outer surface of an introducer needle housed within the lumen of the catheter. The introducer needle is provided to create an opening into the vein of patient through which the catheter tip is inserted. The tapered inner surface ensures a tight seal between the inner surface of the catheter and the outer surface of the needle. Following placement of the catheter, the introducer needle is removed.

In some implementations, a peripheral catheter is provided comprising a catheter body having an outer surface, a proximal end, a distal end, a lumen extending between the proximal and distal ends, and a distal lumen opening, the catheter further including a recess formed in the outer surface of the catheter body. In some implementations, a diffusion hole is further positioned within the recess through a wall thickness of the catheter body. As such, the recessed location of the diffusion hole is removed from directly contacting the skin or other tissues of the patient during insertion of the catheter. Accordingly, the diffusion hole is prevented from snagging the skin or tissues of the patient.

In some implementations, a method for manufacturing a snag-resistant, vented catheter is provided, wherein the method includes the steps of providing a catheter body having an outer surface, a proximal end, a distal end, a lumen extending between the proximal and distal ends, and a lumen opening. The method further includes the steps of providing a recess in the outer surface of the catheter body, and further providing a diffusion hole in the recess through a wall thickness of the catheter body. As such, the recessed location of the diffusion hole is removed from directly contacting the skin or other tissues of the patient during insertion of the catheter. Accordingly, the diffusion hole is prevented from snagging the skin or tissues of the patient.

Further, in some implementations, a peripheral catheter is provided comprising a catheter body having a predetermined wall thickness, the catheter body member having a proximal end, a distal end, a lumen extending between the proximal and distal ends, and a distal lumen opening, the catheter body further having a truncated length to access a peripheral vein of a patient. In some implementations, the peripheral catheter further comprises a recess formed in the outer surface of the catheter body, wherein a hole is provided within the recess through the predetermined wall thickness and in communication with the lumen. As such, the recessed location of the diffusion hole is removed from directly contacting the skin or other tissues of the patient during insertion of the catheter. Accordingly, the diffusion hole is prevented from snagging the skin or tissues of the patient.

The present invention further includes methods for manufacturing an intravenous catheter for diffusing an infusant. Some methods include the steps of providing an intravenous catheter and forming a plurality of staggered holes through the wall thickness of the intravenous catheter. Some methods of the present invention further include using a laser drill to

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provide the various staggered holes. Still further, some methods of the present invention include extrusion and co-extrusion processes for providing the catheter body and various other features discussed in detail below.

BRIEF DESCRIPTION OF THE SEVERAL VIEWS OF THE DRAWINGS

In order that the manner in which the above-recited and other features and advantages of the invention are obtained will be readily understood, a more particular description of the invention briefly described above will be rendered by reference to specific embodiments thereof which are illustrated in the appended drawings. These drawings depict only typical embodiments of the invention and are not therefore to be considered to limit the scope of the invention.

FIG. 1 is a perspective view of an infusion system in accordance with a representative embodiment of the present invention.

FIG. 2 is a detailed perspective view of a catheter in accordance with a representative embodiment of the present invention.

FIG. 3 is a perspective view of a catheter tip in accordance with a representative embodiment of the present invention.

FIG. 4 is a cross-section side view of the catheter tip in accordance with a representative embodiment of the present invention.

FIG. 5 is a cross-section side view of a catheter tip during catheterization in accordance with a representative embodiment of the present invention.

FIG. 6A is a cross-section end view of a catheter tip during catheterization in accordance with a representative embodiment of the present invention.

FIG. 6B is a cross-section end view of a catheter tip during catheterization, the catheter tip incorporating a stiffening material in accordance with a representative embodiment of the present invention.

FIG. 7 is a detailed cross-section end view of a catheter tip having a flow breaking feature in accordance with a representative embodiment of the present invention.

FIG. 8 is a perspective view of a catheter tip in accordance with a representative embodiment of the present invention.

DETAILED DESCRIPTION OF THE INVENTION

Embodiments of the present invention will be best understood by reference to the drawings, wherein like reference numbers indicate identical or functionally similar elements. It will be readily understood that the components of the present invention, as generally described and illustrated in the figures herein, could be arranged and designed in a wide variety of different configurations. Thus, the following more detailed description, as represented in the figures, is not intended to limit the scope of the invention as claimed, but is merely representative of presently preferred embodiments of the invention.

The systems and methods of the present invention are generally designed for use in combination with a vascular infusion system capable of rapidly delivering an infusant to the vascular system of a patient. Referring now to FIG. 1, a vascular infusion system 100 is shown, in accordance with a representative embodiment of the present invention. Infusion systems of this type are commonly configured to operate at internal pressures up to 2000 psi. Many systems operate in the range of 75 to 2000 psi, while specific devices of this type operate at 100, 200, and 300 psi. The vascular infusion system 100 comprises a vascular access device 112 coupled to an

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injector pump **120** via a coiled extension set **130**. In some embodiments, the infusion system **100** further comprises a safety device **140** positioned between the vascular access device **112** and the injector pump **120**. In some embodiments, a safety device **140** is provided to automatically occlude the fluid path of the infusion system **100**, thereby preventing excessive pressure buildup in downstream infusion components.

An injector pump **120** generally comprises a fluid pumping apparatus configured to rapidly deliver an infusant, such as blood, medicaments, and CT scan contrast agents to a patient's vascular system. Desirable infusants may also include various fluids often of high viscosity as required for medical and diagnostic procedures. In some embodiments, the injector pump **120** comprises a power injector capable of delivering an infusant to a patient at flow rates from about 10 mL/hour up to about 1200 mL/minute. In some embodiments, a high infusion flow rate is desirable for medical procedures which require enhanced bolus density of an infusant in a patient's vascular system. For example, a trend in diagnostic imaging procedures is to utilize contrast media enhancement, which requires more viscous contrast media to be pushed into a patient at a higher flow rate, thereby resulting in increased image quality. Thus, in some embodiments an injector pump **120** and a vascular access device **112** are selected to compatibly achieve a desired infusion flow rate.

A coiled extension set **130** generally comprises flexible or semi-flexible polymer tubing configured to deliver an infusant from the injector pump **120** to the vascular access device **112**. The extension set **130** includes a first coupler **132** for connecting the extension set **130** to a downstream device **112** or **140**. The extension set **130** also includes a second coupler **134** for connecting the extension set **130** to the injector pump **120**. A coiled configuration of the extension set **130** generally prevents undesirable kinking or occlusion of the set **130** during infusion procedures. However, one of skill in the art will appreciate that the extension set **130** may include any configuration capable of efficiently delivering an infusant from an injector pump **120** to the patient via a vascular access device **112**. In some embodiments, the extension set **130** is coupled between a syringe and a vascular access device whereby an infusant is manually injected into a patient. In other embodiments, the infusion system comprises only a syringe and a vascular access device, in accordance with the present invention.

The vascular access device **112** generally comprises a peripheral intravenous catheter **114**. A peripheral intravenous catheter **114** in accordance with the present invention generally comprises a short or truncated catheter (usually 13 mm to 52 mm) that is inserted into a small peripheral vein. Such catheters generally comprise a diameter of approximately a 14 gauge catheter or smaller. Peripheral intravenous catheters **114** are typically designed for temporary placement. The short length of the catheter **114** facilitates convenient placement of the catheter but makes them prone to premature dislodging from the vein due to movement of the patient and/or recoil forces experienced during infusion procedures. Furthermore, unlike midline or central peripheral catheters, peripheral intravenous catheters **114** in accordance with the present invention comprise a tapered catheter tip **146** to accommodate use with an introducer needle (not shown) designed to aid in insertion of the catheter **114**.

An introducer needle is typically inserted through the catheter **114** such that a tip of the needle extends beyond the tapered tip **146**. The tapered geometry of the tapered tip **146** conforms tightly to the outer surface of the introducer needle. Both the outer surface and the inner surface of the tip **146** are

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tapered towards the distal end of the catheter **114**. The outer surface of the tip **146** is tapered to provide a smooth transition from the smaller profile of the introducer needle to the larger profile of the catheter outer diameter. Insertion of the introducer needle into the vein of the patient provides an opening into the vein through which the tapered tip **146** of the catheter **114** is inserted. The tapered outer surface of the tip **146** enables easy insertion of the catheter **114** into the opening. Once the peripheral intravenous catheter **114** is inserted into the vein of the patient, the introducer needle (not shown) is removed from the lumen of the catheter **114** to permit infusion via the catheter **114**.

A desired infusant is typically delivered to the catheter **114** via a section of intravenous tubing **116** coupled to the catheter **114**. In some embodiments, a y-adapter **118** is coupled to an end of the tubing **116** opposite the catheter **114**, enabling the vascular access device **112** to be coupled to the remainder of the vascular infusion system **100**. One of skill in the art will appreciate the possible variations and specific features of available vascular access devices **112**, as are commonly used in the medical and research professions. For example, in some embodiments a catheter **114** in accordance with the present invention may include additional access sites, clamps, parallel intravenous lines, valves, couplers, introducer needles, coatings, and/or materials as desired to fit a specific application.

Referring now to FIG. 2, a catheter **214** is shown in accordance with a representative embodiment of the present invention. Catheter **214** generally comprises a catheter adapter **218** configured to house a tubular body member **220**. Catheter adapter **218** further includes an inlet port **230** that is coupled to a section of intravenous tubing **216**. The section of intravenous tubing **216** is further coupled to upstream infusion components, as shown and described in connection with FIG. 1, above.

The catheter adapter **218** facilitates delivery of an infusant within the intravenous tubing **216** to a patient via the tubular body member **220**. An inner lumen of the catheter adapter **218** is in fluid communication with both an inner lumen of the intravenous tubing **216** and an inner lumen of the tubular body member **220**. In some embodiments, catheter adapter **218** further comprises an access port **222**. The access port **222** is generally provided to permit direct access to the inner lumen of the catheter adapter **218**. In some embodiments, the access port **222** is accessed via a needle and a syringe to deliver an infusant to a patient via the tubular body member **220**. In other embodiments, an introducer needle or guide wire is inserted into the access port **222** and advanced through the inner lumen of the tubular body member **220**. In some embodiments, a tip portion of the introducer needle or guide wire (not shown) extends beyond a tip portion **240** of the tubular body member **220**. As such, the tip portion of the introducer needle or guide wire may provide an opening into the vascular system of a patient into which the tubular body member **220** is inserted. Following placement of the tubular body member **220** into the vein of the patient, the introducer needle or guide wire is removed from the access port **222** thereby establishing fluid communication between the tubular body member **220**, the catheter adapter **218** and the intravenous tubing **216**.

In some embodiments, the tubular body member **220** comprises an intravenous catheter. The intravenous catheter **220** generally comprises a flexible or semi-flexible biocompatible material, as commonly used in the art. In some embodiments, the intravenous catheter **220** comprises a polymer material, such as polypropylene, polystyrene, polyvinylchloride, polytetrafluoroethylene, and the like. In other embodiments, the

intravenous catheter **220** comprises a metallic material, such as surgical steel, titanium, cobalt steel, and the like.

The tubular body member **220** may comprise any length, where the length is selected based on the intended application of the catheter **214**. For some applications, the tubular body member **220** is inserted into a peripheral vein of the patient. In other applications, the tubular body member **220** is inserted into a central vein of the patient. In some embodiments, the tip portion **240** of the tubular body member **220** is modified to include a recess **248** formed in the wall thickness of the tubular body member **220**, as shown in FIGS. 2 and 3.

With continued reference to FIGS. 2 and 3, recess **248** generally comprises a small concavity defined by adjacent sidewalls or chamfered surfaces **249**. In some embodiments recess **248** further comprises a diffusion hole **250** to facilitate rapid infusion applications. Diffusion hole **250** is generally provided to divert fluid from the main channel of flow through the inner lumen of the tubular body member **220**. As such, diffusion hole **250** effectually slow the jet of infusant which issues from the catheter tip **240** during rapid infusion procedures. Additionally, diffusion hole **250** increases the accumulative area of the catheter tip opening **242** to relieve the overall pressure in the vascular infusion system **100**. In some embodiments, diffusion hole **250** comprises one or more side holes which meet the requirements of International Standard ISO 10555-2, section 4.4.3.

In some embodiments, tubular body member **220** further comprises a plurality of recesses, as shown in FIG. 4. For example, in some embodiments tubular body member **220** comprises a second recess **258** positioned opposite recess **248**. Second recess **258** further comprises a second diffusion hole **251** positioned opposite diffusion hole **250**. In some embodiments, a plurality of recesses and diffusion holes are provided in adjacent, annular rings along the length of tubular body member **220**. In other embodiments, the plurality of recess and diffusion holes are provided in a staggered pattern of adjacent, annular rings along the length of tubular body member **220**. As such, an upstream recess and diffusion hole is unaligned with an adjacent, downstream recess and diffusion hole.

Recesses **248** and **258** are generally provided by manufacturing methods known in the art. For example, in some embodiments recesses **248** and **258** are provided via an extrusion process. In other embodiments, recesses **248** and **258** are provided via an etching process, such as laser etching. Further, diffusion holes **250** and **251** are generally provided by manufacturing methods known in the art. For example, in some embodiments the plurality of diffusion holes **250** and **251** are provided with a laser drill.

In some embodiments, recesses **248** and **258** are symmetrically positioned on tubular body member **220** so as to prevent catheter tip **240** from being displaced due to lateral forces caused by an infusant exiting diffusion holes **250** and **251**. For example, in some embodiments a tubular body member **220** is provided having three recesses, wherein each recess comprises a diffusion hole radially spaced approximately 120° from an adjacent diffusion hole. In further example, some embodiments comprise a tubular body member **220** having greater than three recesses and greater than three diffusion holes.

Alternatively, in some embodiments tubular body member **220** is modified to include a plurality of axial ridges **266** formed on the outer surface of tubular body member **220** by extrusion or another heat forming method. Diffusion holes **250** and **251** may be placed between axial ridges **266**, as shown. During catheterization (i.e.: insertion of tubular body **220** into the vascular system of a patient), axial ridges **266** lift

the skin and other tissues of the patient over diffusion holes **250** and **251** thereby preventing tissue from getting snagged in the diffusion holes, as discussed below.

In some embodiments, diffusion holes **250** and **251** are formed through the catheter wall **260** such that an inner surface **252** of each hole is oriented at an angle **262** that is oblique to an inner surface **272** of the catheter lumen **270**. In some embodiments, angle **262** is between about 15° to about 75°. In other embodiments, angle **262** is approximately 45°. Further, in some embodiments angle **262** is approximately 90° relative to inner surface **252**.

In some embodiments, the bore angle **262** further affects the positioning of the catheter within the vein of patient. For example, when inserted into a vein the venous catheter generally extends through the skin and into the vein at approximately 30°. As such, the tip of the venous catheter commonly contacts or rests against the inner wall of the vein opposite the insertion site of the catheter. As fluid flow increases, high jet velocity from the catheter tip is exerted directly on the inner wall of the vein. However, when the tip of the venous catheter is modified to include diffusion holes, the diverted infusant that issues from the diffusion holes pushes the catheter tip away from the vein wall resulting in a centralized position of the catheter tip within the vein. Thus, the jet velocity from the tip is directed into the fluid stream of the vein rather than into the vein wall. Accordingly, in some embodiments the bore angle **262** of diffusion holes **250** and **251** is selected to achieve optimal centralized positioning of catheter tip **240** within the vasculature of the patient during infusion procedures.

Referring now to FIG. 5, a distal end portion **242** of venous catheter **214** is shown, in accordance with a representative embodiment of the present invention. As previously discussed, in some embodiments an outer surface of catheter tip **240** is tapered so as to provide a gradual transition from catheter opening **242** of tip **240** to the diameter of tubular body **220**. Further, in some embodiments the outer surface of catheter tip **240** is tapered so as to provide a gradual transition from the outer diameter of an introducer needle **300** to the diameter of tubular body **220**, as shown.

In some embodiments, venous catheter **214** comprises an over-the-needle catheter. Thus, in some embodiments an opening **320** is provided within the skin **302** or other tissue of the patient by an introducer needle **300** housed within the catheter lumen **270**. In some embodiments, a tip **310** of the introducer needle **300** is positioned external to the catheter lumen **270** so as to provide an exposed cutting surface by which to provide an opening **320** into the vasculature of the patient. Upon advancing the venous catheter into the patient, the tapered configuration of tubular body **220** permits easy passage of the catheter's tip **240** in opening **320**.

As shown, axial ridges **266** lift the skin **302** or other tissues of the patient away from diffusion holes **250** and **251** during catheterization. Alternatively, recesses **248** and **258** position diffusion holes **250** and **251** away from opening **320** thereby preventing undesirable contact or snagging between the diffusion holes and opening **320**. Thus, in some embodiments axial ridges **266** and/or recesses **248** and **258** increase the snag-resistance of catheter tip **240**, as shown in FIG. 6A.

With continued reference to FIG. 6A, in some instances diffusion holes **250** and **251** further comprise an outer opening **253** having a perimeter defining a first surface area, and an inner opening **255** having a perimeter defining a second surface area, wherein the first surface area is greater than the second surface area. In other instances, the first surface area of outer opening **253** is less than the second surface area of inner opening **255**, as shown in FIG. 4.

In some embodiments, the inclusion of diffusion holes at or near the tip of a short catheter may result in a reduction of buckling resistance for the catheter thereby making the catheter more susceptible to crushing during catheterization. Accordingly, in some embodiments axial ridges **266** further increase the bending and buckling stiffness of catheter tip **240**, thereby minimizing the risks of catheter tip crushing or buckling during insertion. One having ordinary skill in the art will therefore appreciate and recognize that the stiffening effect of axial ridges **266** may be accomplished by any number of structural modifications wherein the thickness and/or rigidity of the catheter wall **260** between diffusion holes **250** and **251** is increased to withstand compression and/or shear forces during insertion.

For example, in some embodiments the rigidity of the catheter wall **260** positioned between diffusion holes **250** and **251** is increased by the addition of a stiffening material **290**, as shown in FIG. **6B**. In some embodiments, stiffening material comprises a rigid or semi-rigid radiopaque material, such as a wire or an extruded filler material which may include a chemical salt of bismuth or barium, or an element such as platinum or tungsten. In some embodiments stiffening material **290** comprises barium sulfate. In other embodiments, stiffening material **290** comprises a polymer material having an increased density as compared to the remaining polymer material of the venous catheter **214**. In some embodiments, venous catheter **214** and stiffening material **290** are coextruded, wherein stiffening material **290** is embedded within the wall thickness of the tubular body member **220**. In other embodiments, stiffening material **290** is applied directly to the external surface of tubular body member **220**, thereby forming axial ridges **266**.

Referring now to FIG. **7**, in some embodiments sidewalls **249** further comprise a flow breaking feature **280**. A “flow breaking feature” refers to a feature of the diffusion hole **250** and/or a physical feature adjacent to the diffusion hole **250** that substantially breaks up, thins, or slows a jet of infusant exiting the diffusion hole **250** so that the jet will lose speed more quickly within the vein.

FIGS. **2-7** generally depict circular diffusion holes. However, in some embodiments one or more diffusion holes may be non-circular. For example, in some embodiments flow breaking feature **280** may include a flow disrupter, elongated diffusion hole geometries, and diffusion hole orientations such that the axis of flow of two or more diffusion holes collide. In some embodiments, flow breaking feature **280** is a flow disrupter comprising an inward projection that contacts the jet of infusant exiting diffusion hole **250**. In other embodiments, flow breaking feature **280** is a flow disrupter including a pointed extension. Further, in some embodiments feature **280** comprises a plurality of inward projections. An “inward projection” refers to a portion of a diffusion hole’s periphery which projects toward the inner portion of the diffusion hole.

In some embodiments, a single diffusion hole includes more than one flow breaking features. Examples of flow breaking features are described herein, including at least inward projections, wedged extensions, an elongated diffusion hole geometry, and diffusion hole axis orientations that result in collisions with other fluid jets. For example, in some embodiments, a diffusion hole includes an inward projection and has an axis orientation that collides with that of another hole. In addition, in some embodiments the diffusion hole further includes a wedged extension. In other embodiments, other combinations of flow breaking features are combined to provide a less harmful, more effective catheter diffusion hole and diffusion hole array configuration.

From the foregoing, it will be seen that one or more flow breaking features can be included on one or more catheter diffusion holes on a catheter tip. The flow breaking features can substantially break up, thin, or slow a jet of fluid exiting a diffusion hole so that the jet will lose speed more quickly within the vein and cause less damage to vessel walls. In particular, flow breaking features are particularly advantageous when used in rapid infusion therapy that uses highly infusant velocities to rapidly introduce a bolus of fluid into a patient through the catheter tip. During these procedures, one or more flow breaking features of a diffusion hole can increase infusion patient comfort, decrease patient pain, allow for greater infusion velocities, and prevent vessel damage.

Referring now to FIG. **8**, in some embodiments recess **288** and axial ridges **296** are extended along the length of tubular body **220**, thereby accommodating a plurality of recessed diffusion holes **298**. Accordingly, the sum of the exiting infusant jets from recessed diffusion holes **298** will produce a fluid infusion with less impact energy and which poses a lesser risk to the patient’s vessel walls. In some embodiments, recess **288** comprises a non-linear recess thereby providing a non-linear alignment of recessed diffusion holes **298**. For example, in some embodiments recess **288** comprises a helical recess, wherein recess **288** circumscribes the outer surface of tubular member **220** in a helical fashion. In other embodiments, recess **288** comprises a plurality of longitudinal recesses, wherein a portion of each longitudinal recess is intersected with a ridge thereby dividing each longitudinal recess into two or more sections.

The present invention may be embodied in other specific forms without departing from its structures, methods, or other essential characteristics as broadly described herein and claimed hereinafter. The described embodiments are to be considered in all respects only as illustrative, and not restrictive. The scope of the invention is, therefore, indicated by the appended claims, rather than by the foregoing description. All changes that come within the meaning and range of equivalency of the claims are to be embraced within their scope.

The invention claimed is:

1. A peripheral catheter, comprising:

a catheter body having a central axis, an outer surface of the catheter body being coaxial with and radially spaced from the central axis at a first distance, the catheter body also including a single centrally located lumen coaxial to the central axis, the single centrally located lumen having an annular inner surface that is coaxial with and radially spaced from the central axis at a second distance, the single centrally located lumen extending between a proximal end and a distal end of the catheter body and comprising a distal lumen opening, the single centrally located lumen providing a fluid path through which power injections of fluid are transmitted from the single centrally located lumen and into a vasculature of a patient;

a recess formed in the outer surface of the catheter body, the recess comprising opposing sidewalls that radially extend inwardly from the outer surface to a recess surface that extends between the opposing sidewalls, the recess surface being located at a third distance from the central axis, wherein the third distance is between the first distance and the second distance; and

a hole formed through the recess surface and into the single centrally located lumen such that power injected fluids exit the single centrally located lumen via the distal lumen opening and the hole positioned in the recess, the hole comprising a sidewall having an outer edge, the

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outer edge located at the third distance and an inner edge located at the second distance, the hole also being positioned completely within the recess such that there is a portion of the recess surface between the sidewall of the hole and each sidewall of the recess.

2. The peripheral catheter of claim 1, wherein the hole comprises a plurality of holes through which the power injected fluids exit the single centrally located lumen.

3. The peripheral catheter of claim 1, further comprising a plurality of recesses, wherein each of the recesses comprises at least one hole through which the power injected fluids exit the single centrally located lumen.

4. The peripheral catheter of claim 1, wherein the catheter body includes a tapered distal end, the recess being formed in the tapered distal end such that the first, second, and third distances are tapered.

5. The peripheral catheter of claim 4, further comprising a flow breaking feature positioned on a chamfered surface.

6. The peripheral catheter of claim 5, wherein the flow breaking feature includes a flow disrupter.

7. The peripheral catheter of claim 6, wherein the flow disrupter is an inward projection.

8. The peripheral catheter of claim 1, wherein a bore angle of the hole is oblique to an inner wall surface of the single centrally located lumen.

9. A method for manufacturing a snag-resistant, vented peripheral catheter, the method comprising:

providing a catheter body having a central axis, an outer surface of the catheter body being coaxial with and radially spaced from the central axis at a first distance, the catheter body also including a single centrally located lumen coaxial to the central axis, the single centrally located lumen having an annular inner surface that is coaxial with and radially spaced from the central axis at a second distance, the single centrally located lumen extending between a proximal end, and a distal end of the catheter body and comprising a distal lumen opening, the single centrally located lumen providing a fluid path through which power injections of fluid are transmitted from the single centrally located lumen and into a vasculature of a patient;

providing a recess in the outer surface of the catheter body, the recess comprising opposing sidewalls that radially extend inwardly from the outer surface to a recess surface that extends between the opposing sidewalls, the recess surface being located at a third distance from the central axis, wherein the third distance is between the first distance and the second distance; and

providing a hole formed through the recess surface and into the single centrally located lumen such that power injected fluids exit the single centrally located lumen via the distal lumen opening and the hole positioned in the recess, the hole comprising a sidewall having an outer edge located at the third distance and an inner edge located at the second distance, the hole also being positioned completely within the recess such that there is a portion of the recess surface between the sidewall of the hole and each sidewall of the recess.

10. The method of claim 9, further comprising the step of providing a plurality of holes in the recess through which the power injected fluids exit the single centrally located lumen.

11. The method of claim 9, further comprising the step of providing a plurality of recesses, wherein each of the recesses comprises at least one hole through which the power injected fluids exit the single centrally located lumen.

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12. The method of claim 9, further comprising the step of interposing a flow breaking feature between the hole and the outer surface of the catheter body.

13. The method of claim 12, wherein the flow breaking feature comprises a portion of a chamfered surface interposed between the hole and the outer surface of the catheter body.

14. The method of claim 12, wherein the flow breaking feature includes a flow disrupter.

15. The method of claim 9, wherein a bore angle of the hole is oblique to an inner wall the annular inner surface of the single centrally located lumen.

16. A vascular access device comprising:

a catheter adapter;

a catheter extending from a distal end of the catheter adapter, the catheter having a central axis, an outer surface of the catheter being coaxial with and radially spaced from the central axis at a first distance, the catheter also including a single centrally located lumen coaxial to the central axis, the single centrally located lumen having an annular inner surface that is coaxial with and radially spaced from the central axis at a second distance, the single centrally located lumen extending between a proximal end and a distal end of the catheter and comprising a distal lumen opening, the single centrally located lumen providing a fluid path through which power injections of fluid are transmitted from the single centrally located lumen and into a vasculature of a patient,

the catheter including a recess formed in the outer surface, the recess comprising opposing sidewalls that radially extend inwardly from the outer surface to a recess surface that extends between the opposing sidewalls, the recess surface being located at a third distance from the central axis, wherein the third distance is between the first distance and the second distance,

the catheter further including a hole formed through the recess surface and into the single centrally located lumen such that power injected fluids exit the single centrally located lumen via the distal lumen opening and the hole positioned in the recess, the hole comprising a sidewall having an outer edge, the outer edge located at the third distance and an inner edge located at the second distance, the hole also being positioned completely within the recess such that there is a portion of the recess surface between the sidewall of the hole and each sidewall of the recess;

an introducer needle that is contained within the single centrally located lumen and extends distally from the distal lumen opening of the catheter.

17. The vascular access device of claim 16, further comprising a flow breaking feature positioned on one or both of the sidewalls.

18. The vascular access device of claim 16, wherein the catheter further comprises a stiffening material embedded within a wall thickness of the catheter.

19. The vascular access device of claim 18, wherein the stiffening material comprises a plurality of strips of the stiffening material that are spaced within and extend along a length of a tapered tip.

20. The vascular access device of claim 16, wherein the catheter includes a tapered distal end, the recess being formed in the tapered distal end such that the first, second, and third distances are tapered.

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